

3940



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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RB KIT 407M
Job Sheet 184589



10-22

Part No: RB KIT 407M

Job Qty: 1 ea

Part Name: Spline Measuring



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/12/18

Job Tracking No:

Due Date: 10/22/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RB KIT 407M REV.C IPP REV A 18.01.25 NEW ISSUE RQ VERIFIED BY DP/IPP Rev B 18.03.08 DWG update Rev. C DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	10/22/18	10/22/18	0.00	0.00	Start Up Small Fab-4		MCL
100	Small Fab	1 pcs	10/22/18	10/22/18	0.08	1.00	Small Fab-9		MCL DAS
110	QC	1 pcs	10/22/18	10/22/18	0.00	0.00	QC5		NOV 26 2018 68
130	Packaging	1 pcs	10/22/18	10/22/18	0.00	0.00	Packaging3-2		MID. 9-89
140	QC21-FG	1 Ea	10/22/18	10/22/18	0.00	0.00	QC21		NOV 26 2018

Part Op 100 - -Print sheet 3 of 5 of the dwg. for labels and cut out. -Place pins in vials with the correct label. -Assemble kit.
Descriptions: 130 - Identify and Stock

GA213



Container No: S128013



Part: RB KIT 407M

Job No: 184589

Serial No/Batch: S128013

Revision: C

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 11/15/18

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
97524A031	Rivet	4 Ea (4 ea)	90-Start up Operation	5089128
071600	Vials w/Lids	16 Ea (16 ea)	100-Small Fab	5077812
APP-1120-E	Case	1 Ea (1 ea)	100-Small Fab	5121991
128A 128A RB KIT 407M-01	Gauge Pin .0240" dia.	2 Ea (2 ea)	100-Small Fab	5126910
90 RB KIT 407M-03	Gauge Pin .0400" dia.	2 Ea (2 ea)	100-Small Fab	5124945
90 RB KIT 407M-05	Gauge Pin .0540" dia.	2 Ea (2 ea)	100-Small Fab	5128745
90 RB KIT 407M-07	Gauge Pin .0600" dia.	2 Ea (2 ea)	100-Small Fab	5052110
90 RB KIT 407M-09	Gauge Pin .0800" dia.	2 Ea (2 ea)	100-Small Fab	5126920
RB KIT 407M-11	Gauge Pin .0960" dia.	2 Ea (2 ea)	100-Small Fab	5052172
RB KIT 407M-13	Gauge Pin .1080" dia.	2 Ea (2 ea)	100-Small Fab	5047878
RB KIT 407M-15	Gauge Pin .1200" dia.	2 Ea (2 ea)	100-Small Fab	5053387
RB KIT 407M-17	Gauge Pin .1440" dia.	2 Ea (2 ea)	100-Small Fab	5052172 5131 277
RB KIT 407M-19	Gauge Pin .1440"	2 Ea (2 ea)	100-Small Fab	5055565
RB KIT 407M-21	Gauge Pin .1600" dia.	2 Ea (2 ea)	100-Small Fab	5052180
RB KIT 407M-23	Gauge Pin .1600" dia.	2 Ea (2 ea)	100-Small Fab	5096636
RB KIT 407M-25	Gauge Pin .1728" dia.	2 Ea (2 ea)	100-Small Fab	5047874
RB KIT 407M-27	Gauge Pin .1728" dia.	2 Ea (2 ea)	100-Small Fab	5047880
RB KIT 407M-29	Gauge Pin .1800" dia.	2 Ea (2 ea)	100-Small Fab	5121647
RB KIT 407M-31	Gauge Pin .1920" dia.	2 Ea (2 ea)	100-Small Fab	5052158
RB KIT 407M-35	Labels	1 pcs (1 ea)	100-Small Fab	5052158
RB KIT 407M-39	Bottom Foam (Ethafoam 220, Black, 2.58 x 4.83 x 7.34) use with case APP-1120-E	1 Ea (1 ea)	100-Small Fab	5123727
128A RB KIT 407M-41	Top Foam (Ethafoam 220, Black, 0.45 x 4.79 x 7.26) use with case APP-1120-E	1 Ea (1 ea)	100-Small Fab	5123728
6000 RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	100-Small Fab	5021040

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	97524A031	4	100	0
100-Small Fab	071600	16	4,728	0
	APP-1120-E	1	8	0
	RB KIT 407M-01	2	4	0
	RB KIT 407M-03	2	6	0
	RB KIT 407M-05	2	7	0
	RB KIT 407M-07	2	7	0
	RB KIT 407M-09	2	6	0
	RB KIT 407M-11	2	9	0
	RB KIT 407M-13	2	10	0
	RB KIT 407M-15	2	7	0
	RB KIT 407M-17	2	6	0
	RB KIT 407M-19	2	7	0
	RB KIT 407M-21	2	11	0
	RB KIT 407M-23	2	47	0
	RB KIT 407M-25	2	10	0
	RB KIT 407M-27	2	12	0
	RB KIT 407M-29	2	11	0
	RB KIT 407M-31	2	7	0
	RB KIT 407M-35	1	0	0
	RB KIT 407M-39	1	2	0
	RB KIT 407M-41	1	2	0
	RB41011	1	763	0

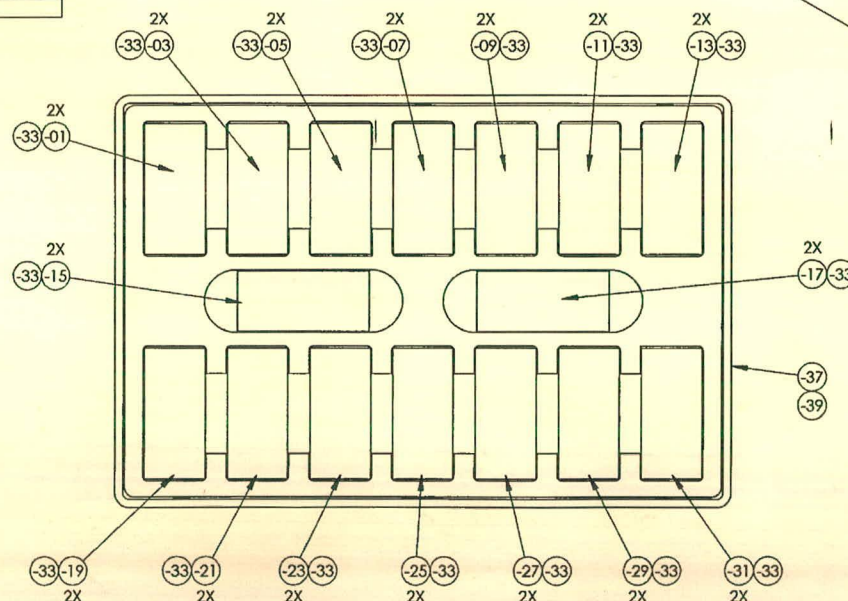
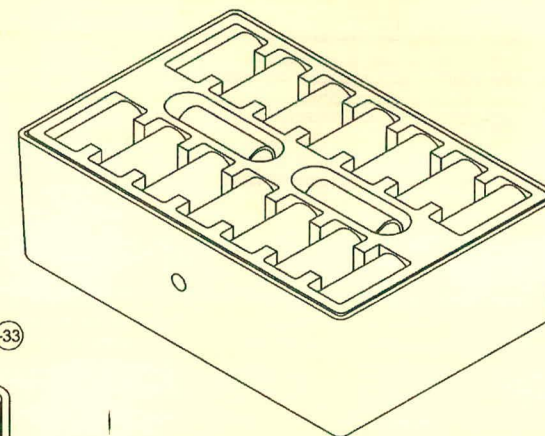
Part Specifications

Specifications could not be found.

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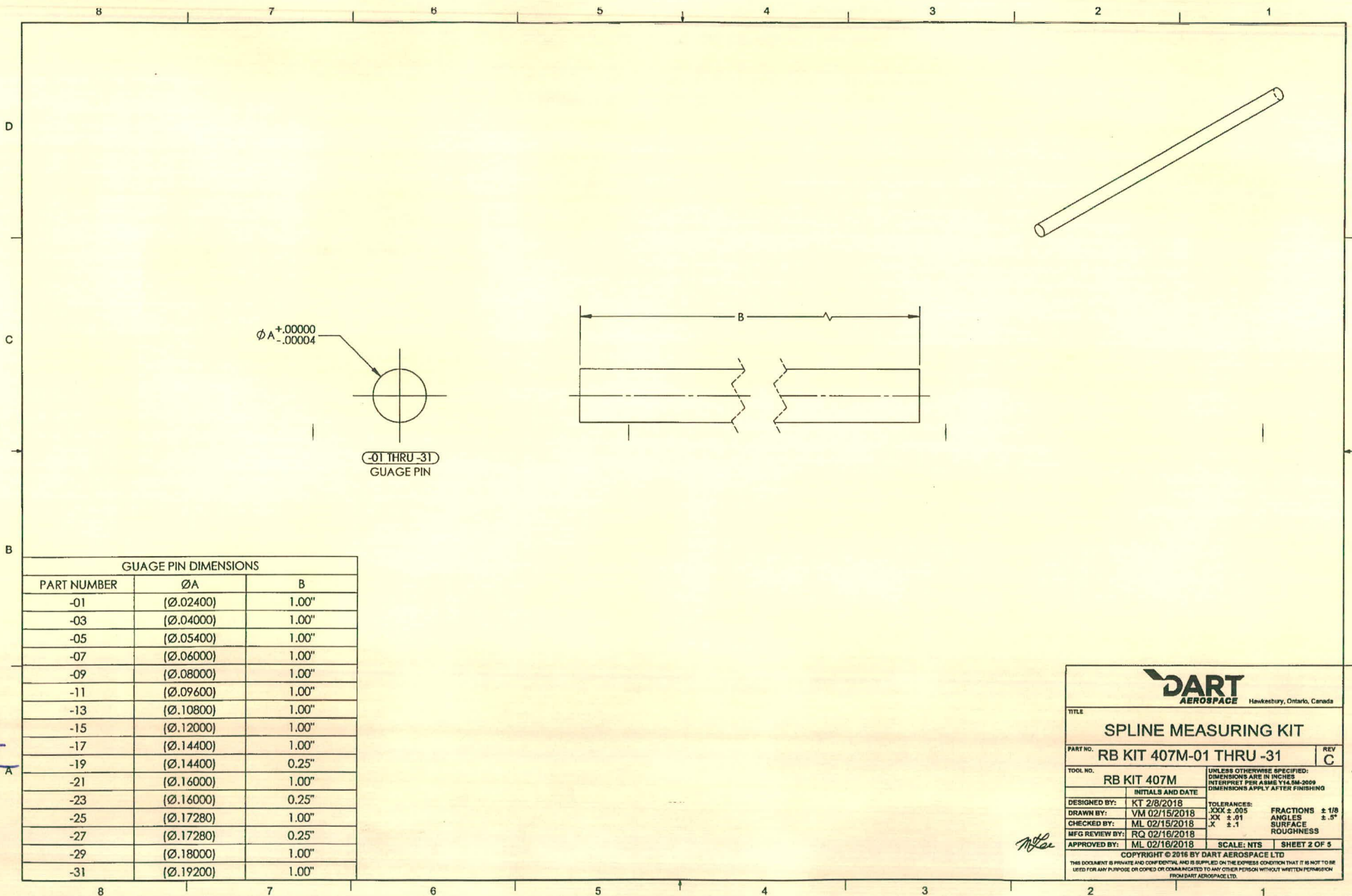
Part #	ASSY QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
-01	2	GAUGE PIN	STEEL	Ø.0240, X CLASS, MINUS
-03	2	GAUGE PIN	STEEL	Ø.0400, X CLASS, MINUS
-05	2	GAUGE PIN	STEEL	Ø.0540, X CLASS, MINUS
-07	2	GAUGE PIN	STEEL	Ø.0600, X CLASS, MINUS
-09	2	GAUGE PIN	STEEL	Ø.0800, X CLASS, MINUS
-11	2	GAUGE PIN	STEEL	Ø.0960, X CLASS, MINUS
-13	2	GAUGE PIN	STEEL	Ø.1080, X CLASS, MINUS
-15	2	GAUGE PIN	STEEL	Ø.1200, X CLASS, MINUS
-17	2	GAUGE PIN	STEEL	Ø.1440, X CLASS, MINUS
-19	2	GAUGE PIN	STEEL	Ø.1440, X CLASS, MINUS
-21	2	GAUGE PIN	STEEL	Ø.1600, X CLASS, MINUS
-23	2	GAUGE PIN	STEEL	Ø.1600, X CLASS, MINUS
-25	2	GAUGE PIN	STEEL	Ø.1728, X CLASS, MINUS
-27	2	GAUGE PIN	STEEL	Ø.1728, X CLASS, MINUS
-29	2	GAUGE PIN	STEEL	Ø.1800, X CLASS, MINUS
-31	2	GAUGE PIN	STEEL	Ø.1920, X CLASS, MINUS
-33	16	VIALS, WITH LIDS	CLEAR STYRENE	Ø5/8 ID X 1-5/8 LA. CONTAINER #071600 OR EQUIVALENT
-35	1	LABELS	PAPER	
-37	1	HARD CASE	BLACK PLASTIC	PELICAN #APP-1120E
-39	1	BOTTOM FOAM	ETHAFOAM 220, BLACK	2.58 X 4.83 X 7.34 (CASE SOLUTIONS) OR EQUIVALENT
-41	1	TOP FOAM	ETHAFOAM 220, BLACK	.45 X 4.79 X 7.26 (CASE SOLUTIONS) OR EQUIVALENT
	1	PLACARD	ALUMINUM	RB41011
	4	RIVET	ALUMINUM	McMaster Carr 97524A031 OR EQUIVALENT

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVE
1		RELEASED FOR PRODUCTION.	12/23/2016	RJC	JAG
2	17-0085	-01 THRU -31 ADDED GAUGE PIN DIMENSIONS TABLE. -39 CH'D DIM WAS 64X R.06 IS 56X R.06. CH'D DEPTH WAS 16X .44 IS 9.78. ADDED FINGER PULLS. -41 CH'D MATERIAL WAS C200 EGGSHELL, BLACK IS ETHAFOAM 220, BLACK.	4/6/2017	RJC	JAG
C	18-537	ADDRESS ON ITEM -35 CHANGED TO HAWKESBURY ADDRESS. REMOVED SPECIFIC SUPPLIER INFO	18.02.08	KT	ML



- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) SPEC: N/A
 - 5) BREAK ALL SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) RB KIT 407M IS A MODIFICATION OF DART RB KIT 407 WITH THE ADDITION OF .0400" DIA. x 1" GAUGE PIN, QTY. 2
 - 8) ENGRAVE P/N & S/N WHERE INDICATED ON DART PLACARD BEFORE INSTALLATION ON PELICAN CASE (ITEM 37)
 - 9) CENTER DART PLACARD ON AVAILABLE AREA OF THE TOP LID OF THE PELICAN CASE (ITEM 37) AND SECURE USING QTY (4) RIVETS
 - 10) CUT ITEM -35 AND INSERT INTO CORRESPONDING VIAL WITH GAUGE PINS
 - 11) HOT GLUE ITEMS 39 & 41 TOP AND BOTTOM FOAM INTO THE PELICAN CASE (ITEM 37) AFTER DART PLACARD'S INSTALLATION
 - 12) PURCHASED GAUGE PINS MAY NEED TO BE CUT TO THE APPROPRIATE LENGTH PER SHEET 2 PRIOR TO PACKAGING

DART AEROSPACE Hawkesbury, Ontario, Canada	
SPLINE MEASURING KIT	
PART NO. RB KIT 407M	
REV C	
TOOL NO. RB KIT 407M	
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES INTERPRET PER ASME Y14.5M-2009 DIMENSIONS APPLY AFTER FINISHING	
DESIGNED BY: KT 2/8/2018	TOLERANCES: XXX ± .005 XX ± .01 X ± .1
DRAWN BY: VM 02/15/2018	FRACTIONS ± 1/8 ANGLES ± 5° SURFACE ROUGHNESS
CHECKED BY: ML 02/15/2018	
MFG REVIEW BY: RQ 02/16/2018	
APPROVED BY: ML 02/16/2018	SCALE: NTS SHEET 1 OF 5
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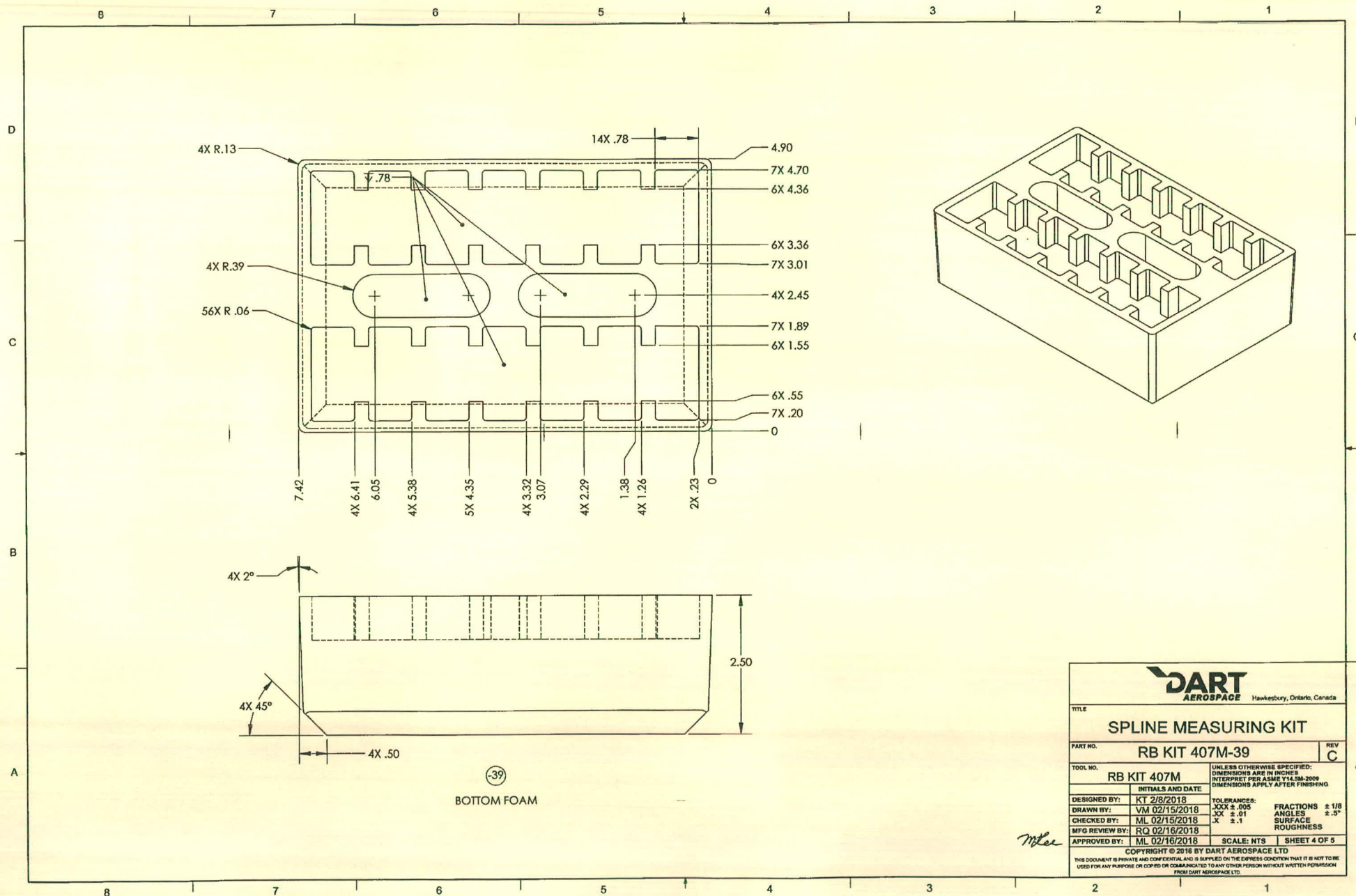
$\phi A^{+.00000}_{-.00004}$

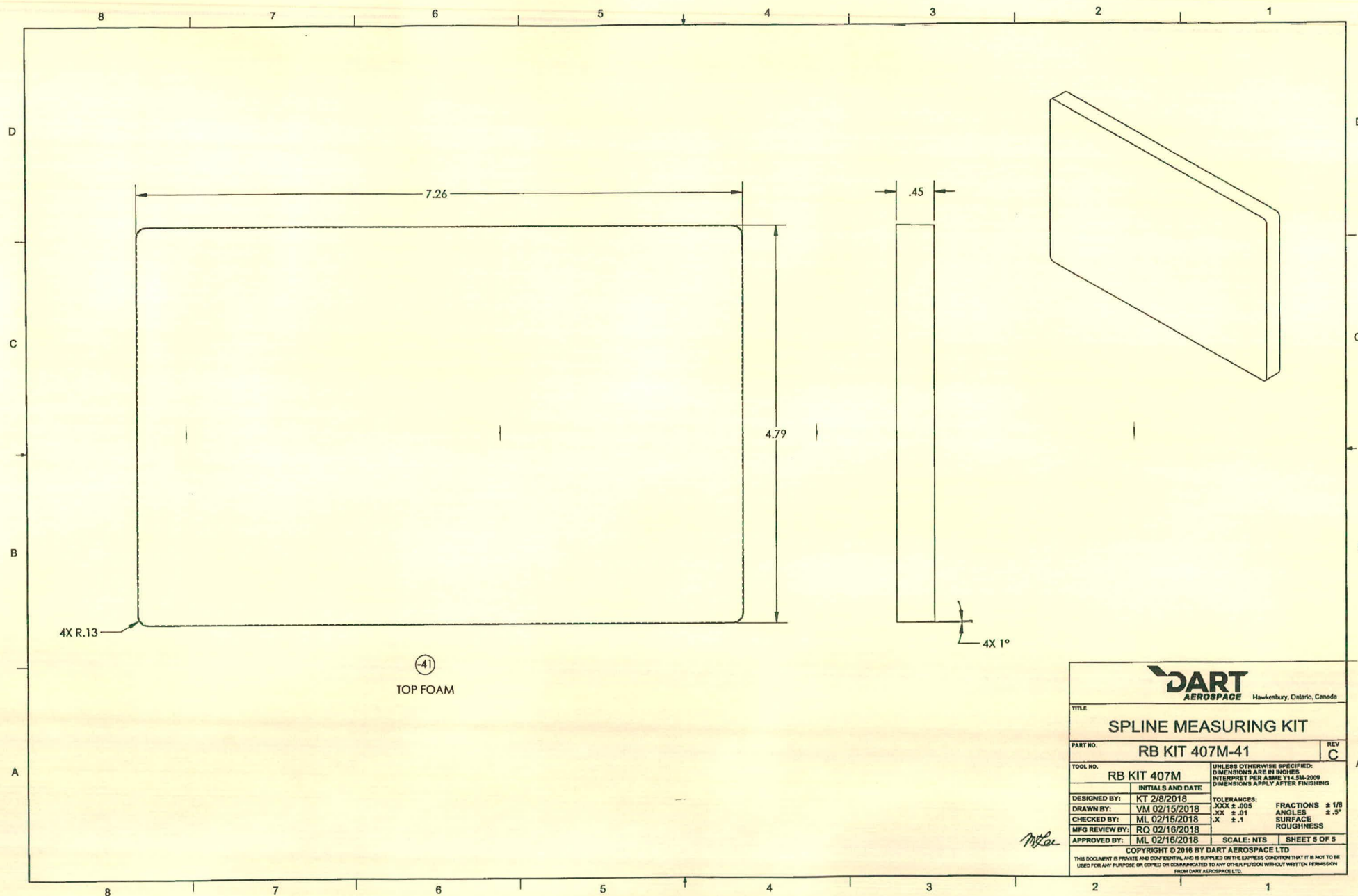
(-01 THRU -31)
GUAGE PIN

GUAGE PIN DIMENSIONS

PART NUMBER	ϕA	B
-01	($\phi .02400$)	1.00"
-03	($\phi .04000$)	1.00"
-05	($\phi .05400$)	1.00"
-07	($\phi .06000$)	1.00"
-09	($\phi .08000$)	1.00"
-11	($\phi .09600$)	1.00"
-13	($\phi .10800$)	1.00"
-15	($\phi .12000$)	1.00"
-17	($\phi .14400$)	1.00"
-19	($\phi .14400$)	0.25"
-21	($\phi .16000$)	1.00"
-23	($\phi .16000$)	0.25"
-25	($\phi .17280$)	1.00"
-27	($\phi .17280$)	0.25"
-29	($\phi .18000$)	1.00"
-31	($\phi .19200$)	1.00"

 Hawkesbury, Ontario, Canada	
TITLE	
SPLINE MEASURING KIT	
PART NO.	REV
RB KIT 407M-01 THRU -31	C
TOOL NO.	
RB KIT 407M	
DESIGNED BY:	INITIALS AND DATE
DRAWN BY:	VM 02/15/2018
CHECKED BY:	ML 02/15/2018
MFG REVIEW BY:	RQ 02/16/2018
APPROVED BY:	ML 02/16/2018
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES INTERPRET FOR ASME Y14.5M-2009 DIMENSIONS APPLY AFTER FINISHING	
TOLERANCES: XXX ± .005 XX ± .01 X ± .1	FRACTIONS ± 1/8 ANGLES ± .5° SURFACE ROUGHNESS
SCALE: NTS	SHEET 2 OF 5
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DART AEROSPACE Hawkesbury, Ontario, Canada	
TITLE SPLINE MEASURING KIT	
PART NO. RB KIT 407M-41	REV C
TOOL NO. RB KIT 407M	
INITIALS AND DATE	
DESIGNED BY: KT 2/8/2018	UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES INTERPRET PER ASME Y14.5M-2009 DIMENSIONS APPLY AFTER FINISHING
DRAWN BY: VM 02/15/2018	TOLERANCES: XXX ± .005
CHECKED BY: ML 02/15/2018	XX ± .01
MFG REVIEW BY: RQ 02/16/2018	X ± .1
APPROVED BY: ML 02/16/2018	SCALE: NTS
SHEET 5 OF 5	

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Dart Aerospace Ltd.
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Order Log

Order No	Order Date	Customer	Ship-To Contact	Part No	Unit Price	Amount	Quantity	Quantity Shipped	Quantity Remaining	Customer Due Date	Ship Date	Customer PO	Status	Type	Priority	Special Comments	Accounting Job No
376	10/13/17	CHELI06 Helikorea		RBT102098	\$1,968.00	\$1,968.00	1	0	1	5/15/18	10/15/18	AIR17P-0366	Open	Reactive	Medium	pricing as per po freight tba lead time 16-18 weeks HBY hold for \$\$\$ contact as per plex ship to HELIKOREA Co.,Ltd. 158, Hanbat-daero 1003beon-gil, Daedeok-gu, Daejeon, 34376, Korea Ship via: DHL account# 969096432, good to go. - Partial Shipment	
				RB T101330P	\$1,850.00	\$1,850.00	1	1	0	5/18/18	5/18/18						
3760	4/13/18	CEURO03 Eurotech SRL		646.4001	\$13,695.00	\$68,475.00	5	0	5				Quoting	Reactive	Medium		
				646.4002	\$3,410.00	\$17,050.00	5	0	5								
2 Orders					Total:	\$89,343.00											

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